

82585

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 03/04/2012 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 17/04/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals:

Process Plan: M25

Date: 12/04/03

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

100	SHEAR	0.00		
100				
Shear	Memo	0.00	10 12-4-16	8
Shear	Cut blanks: 3.70" x 2.70" Drill hole and fillet corner as per Dwg D3214 Deburrid identify as D3214-1			
110	QC5- Inspect part completeness to step on W/O	0.00		
110				
QC	Memo	0.00	Scrubbing	(x8)
Quality Control				
120	Chemical Conversion Coat per QSI005 4.1	0.00		
120				
HandFinish	Memo	0.00		
Hand Finishing				

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82585

April-03-12 10:35:25 AM

82585

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Item ID: D3214-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Placard
Start Date: 03/04/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 17/04/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating w 117338	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 8-15 FINISH TIME: 3200F	0.00 0.00				8X	✓		m/a 12/04/23
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				8	✓		12/4/23
150 *150* HAAS I HAAS CNC vertical machine #1	Small Fab Memo Engrave text as per Folio FA394 and Dwg D3214	0.00 0.00				8		12-05-12	(88)

W/O:			WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Quality Control

45 12.05 - 12 (x6)

12/5/14

12/5/14 JH
MF
12-05-14

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 82585

82585

Parent Item: D3214-1

D3214-1

Parent Item Name: Placard

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.04.15New issueKJ/RF
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			110	sf	596.3200	0.0743	0.469263			

M6061T6S 080

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT021

596.32

117285

2.15

119766

39.77

120096

351

120349

11.4

121193

192

8 12-4-16

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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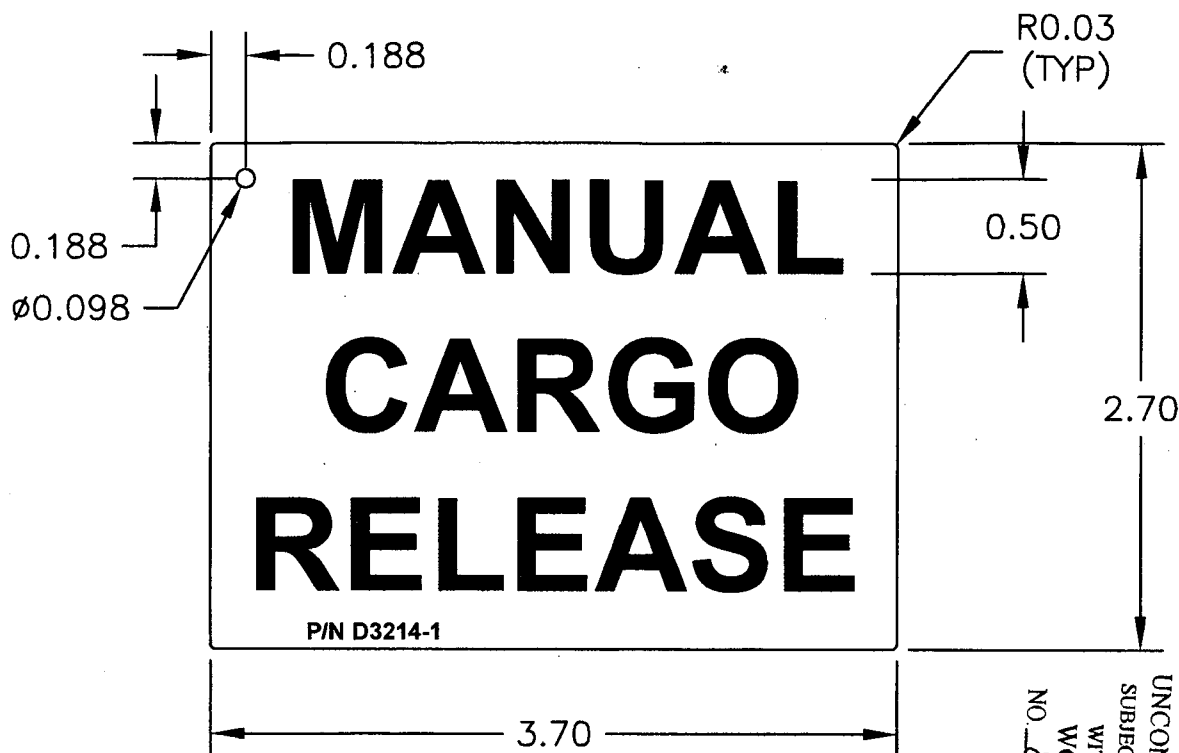
NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3214	REV. B SHEET 1 OF 1
DATE 06.05.29	TITLE PLACARD		SCALE 1:1
A	04.01.27	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

06.06.20 [Signature]

**D3214-1**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82585 MCJ
12/04/03

NOTES

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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